

Date: Wednesday, 3/14/2007 12:25:03 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING PLATE (204 STEP)
Job Number	: 31186		
Estimate Number	: 11846		
P.O. Number	: N/A	Part Number	: D2349
This Issue	: 3/14/2007 S.O. No. : N/A	Drawing Number	: D2349 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: N/A	Material	: N/A
Written By	:	Due Date	: 3/21/2007 Qty: 4 Um: Each
Checked & Approved By	: <u>07.03.14</u>		
Comment	: Est. C 02.11.26 Reformat; Added template KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S080	6061-T6 .080 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.1457 sf(s)/Unit Total : 0.5830 sf(s)
6061-T6 .080 Sheet
Material: 6061-T6, 0.080" Thick
(M6061T6S.080)
Batch: m4894

m07/04/24

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR
Shear blanks as per Dwg D2349 using template D2349T1

m07/04/25

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1
Drill hole as per Dwg D2349 using drilling Jig D2349T1
Deburr

m07/04/25 x4

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

FD

07/04/26 (4)

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

m07 04 26

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 19 Date: 07/04/27

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 12:25:04 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING PLATE (204 STEP)

Job Number: 31186

Part Number: D2349

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: St 27

CP 07/04/26 (4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

07/04/27

Job Completion



U 07-04-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

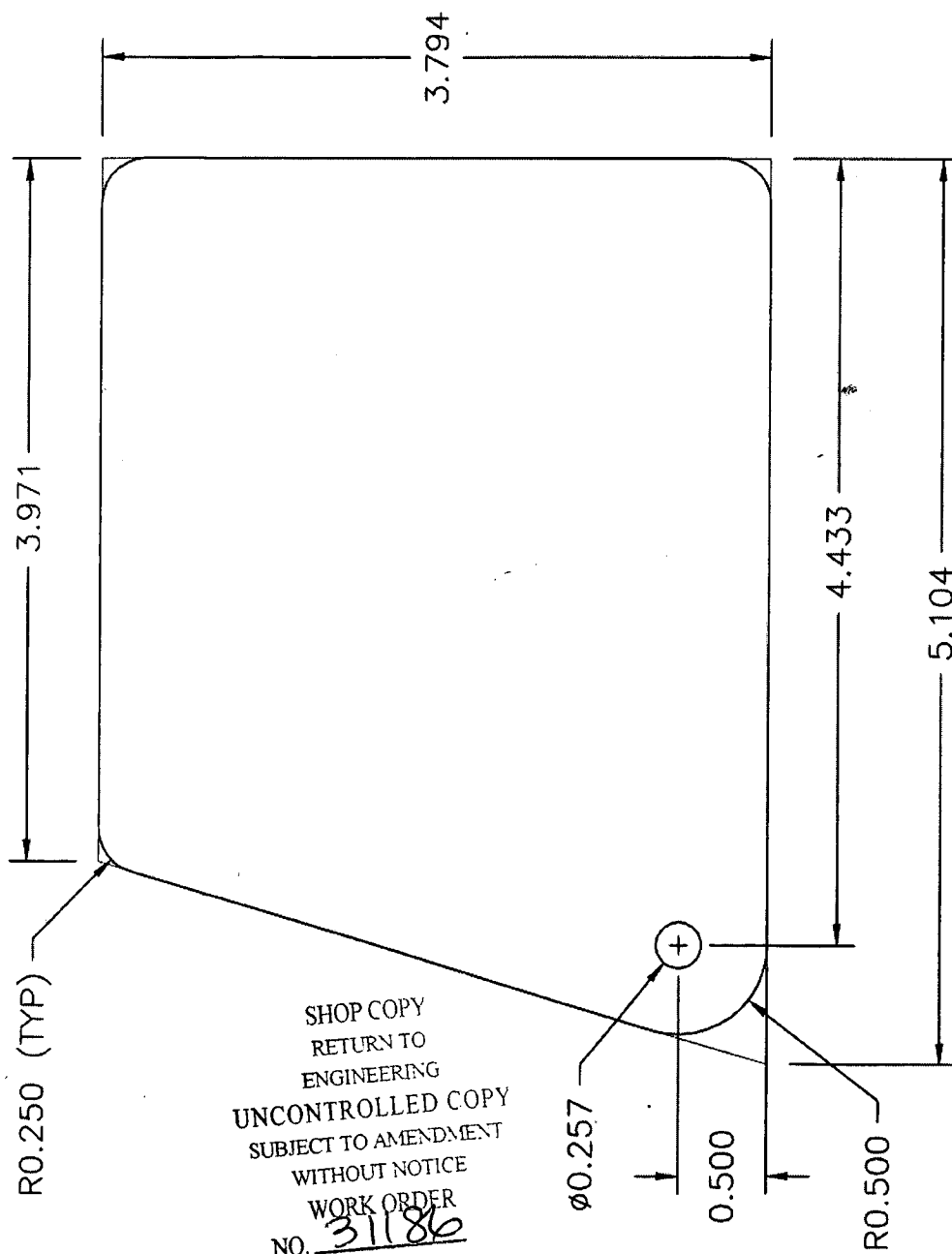
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED <i>[Signature]</i>	DRAWING NO. D2349	REV. C SHEET 1 OF 1
DATE 99.05.04		TITLE MOUNT PLATE	SCALE 1:1
A	95.11.09	NEW ISSUE	
B	96.04.03	RE-DRAWN	
C	99.05.04	ADDED ACID ETCH AND ALODINE	

RELEASED
99.05.11 KE



MATERIAL: 6061-T6 (QQ-A-250/11) 0.080 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED